



Dart Aerospace Ltd.
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D3537-1

Job Sheet 181241



Part No: D3537-1

Job Qty: 52 ea

DAS
21
9-89

Part Name: Wearpad



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-02-14 JLM IPP REV:B 15.10.16 added automated welding DD verf:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		8/31/18	0.00	0.00	Start Up Waterjet		DA 18/07/29
105	Waterjet	50 pcs		8/31/18	0.00	2.15	Waterjet1		DA 18/07/29
125	QC	50 pcs		8/31/18	0.00	0.00	QC8		38
140	Brake NC	50 pcs		8/31/18	0.03	0.65	Brake NC 1		SB 9-89 DAS
150	QC	50 pcs		8/31/18	0.00	0.00	QC5		9
160	Autoweld 1	50 pcs		8/31/18	0.00	3.71	Automated welding		JP 9-89 DAS
170	QC	50 pcs		8/31/18	0.00	0.00	QC10		38 DAS
180	QC	50 pcs		8/31/18	0.00	0.00	QC5		9-89 38
210	Packaging	50 pcs		8/31/18	0.00	0.00	Packaging3-1	FPOD1	BER 18-11-898
220	QC21-SA	50 Ea		8/31/18	0.00	0.00	QC21		DAS 21 9-89 NOV 08 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	5.3000 sf (.106 ea)	90-Start up Operation	5080376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	5	124	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	4.250inches ± 0.010	4.260 4.240		
2	Wearpad	3.500inches ± 0.010	3.510 3.490		
3	Wearpad	1.970inches ± 0.030	2.000 1.940		
4	Wearpad	3.630inches ± 0.030	3.660 3.600		
5	Wearpad	2.420inches ± 0.010	2.430 2.410		
6	Wearpad	0.220inches ± 0.010	0.230		

6:30

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐		
Date : _____		Step # : _____		QTY Effective : _____				MRB (QSI042) Approval		
Description Work Order Deviation										
				Completed By						
				Lead hand / Supervisor Approval Verification						
				QC / QA Coordinator Approval						
Root Cause										
Environment ☐		No Re-verification ☐		 Container No: S097219 Part: D3537 - 1 Job No: 181241 Serial No/Batch: S097219 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Cut Too Short Instructions Incomplete/Unclear Drill Holes						
Design ☐		Operator ☐								
Doc/Data ☐		Offset/Setup ☐								
Equip/Tooling ☐		Supplier ☐								
Handling/Pre ☐		Training ☐								
Material ☐		Use for Testing ☐								
Internal Transport ☐		Poor Information ☐								
Tribal Knowledge ☐		Rushing ☐								
LOA ☐		Product Improvement ☐								
Substation ☐		Process Improvement ☐								
Past Expiry Date ☐		Manufacturing Process ☐								
Misidentified ☐		Past Due ☐								
OTHER : _____										

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www.dartaerospace.com

Date: 07/29/18

DART
AEROSPACE

Container No: S097219

Part: D3537 - 1

Job No: 181241

Serial No/Batch: S097219

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

tube

Marks/Chatter

			0.210
7	Wearpad	0.375inches $\pm$ 0.010	0.385
			0.365
8	Wearpad	0.063inches $\pm$ 0.010	0.073
			0.053

Plex 7/24/18 9:48 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update only ☐

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